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Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
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DSK076  
Job Sheet 201974

Part No: DSK076      Job Qty: 8 pcs  
Part Name: D2891-1 Turning Detail  
  
Part Weight: 0 lbs      Status: New      Priority: Medium  
Job Created: 10/17/19      Job Tracking No:  
Due Date: 11/28/19      Created By: Marie Lajeunesse  
Type: Stock      Description: SIOP  
Note: DWG REV A IPP rev A. 08.03.13 new issue EC  
Ship Via:

Bill of Materials

Job Routing

| Op No | Operation  | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |            |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 100   | Doosan - 1 | 8 pcs | 11/28/19   | 11/28/19 | 0.06      | 5.37    | Doosan - 1            |           | 14/10/21 |
| 110   | QC 2       | 8 pcs | 11/28/19   | 11/28/19 | 0.00      | 0.00    | QC 2 - 1              |           |          |
|       |            |       |            |          |           |         | QC 2 - 12             |           |          |
|       |            |       |            |          |           |         | QC 2 - 14             |           |          |
|       |            |       |            |          |           |         | QC 2 - 17             |           |          |
|       |            |       |            |          |           |         | QC 2 - 19             |           |          |
|       |            |       |            |          |           |         | QC 2 - 2              |           |          |
|       |            |       |            |          |           |         | QC 2 - 20             |           |          |
|       |            |       |            |          |           |         | QC 2 - 22             |           |          |
|       |            |       |            |          |           |         | QC 2 - 23             |           |          |
|       |            |       |            |          |           |         | QC 2 - 25             |           |          |
|       |            |       |            |          |           |         | QC 2 - 32             |           |          |
|       |            |       |            |          |           |         | QC 2 - 33             |           |          |
|       |            |       |            |          |           |         | QC 2 - 35             |           |          |
|       |            |       |            |          |           |         | QC 2 - 39             |           |          |
|       |            |       |            |          |           |         | QC 2 - 4              |           |          |
|       |            |       |            |          |           |         | QC 2 - 40             |           |          |
|       |            |       |            |          |           |         | QC 2 - 44             |           |          |
|       |            |       |            |          |           |         | QC 2 - 45             |           |          |
|       |            |       |            |          |           |         | QC 2 - 48             |           |          |
|       |            |       |            |          |           |         | QC 2 - 49             |           |          |
|       |            |       |            |          |           |         | QC 2 - 50             |           |          |
|       |            |       |            |          |           |         | QC 2 - 51             |           |          |
|       |            |       |            |          |           |         | QC 2 - 52             |           |          |
|       |            |       |            |          |           |         | QC 2 - 57             |           |          |
|       |            |       |            |          |           |         | QC 2 - 62             |           |          |
|       |            |       |            |          |           |         | QC 2 - 63             |           |          |
|       |            |       |            |          |           |         | QC 2 - 8              |           |          |
|       |            |       |            |          |           |         | QC 2 - 66             |           |          |
|       |            |       |            |          |           |         | QC 2 - 64             |           |          |
|       |            |       |            |          |           |         | QC 2 - 65             |           | 14/10/21 |

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|---------------------------------------------|-------|----------|-----------|------------------------|--------------|
| 120 QC 8                                    | 8 pcs | 11/28/19 | 0.00 0.00 | QC 2 - 5               |              |
|                                             |       |          |           | QC 2 - 71              |              |
|                                             |       |          |           | QC 2 - 73              |              |
|                                             |       |          |           | QC 2 - 69              |              |
|                                             |       |          |           | QC 8 - 12              |              |
|                                             |       |          |           | QC 8 - 14              |              |
|                                             |       |          |           | QC 8 - 17              |              |
|                                             |       |          |           | QC 8 - 20              |              |
|                                             |       |          |           | QC 8 - 25              |              |
|                                             |       |          |           | QC 8 - 3               |              |
|                                             |       |          |           | QC 8 - 32              |              |
|                                             |       |          |           | QC 8 - 33              |              |
|                                             |       |          |           | QC 8 - 35              |              |
|                                             |       |          |           | QC 8 - 39              |              |
|                                             |       |          |           | QC 8 - 4               |              |
|                                             |       |          |           | QC 8 - 44              |              |
|                                             |       |          |           | QC 8 - 45              |              |
|                                             |       |          |           | QC 8 - 49              |              |
|                                             |       |          |           | QC 8 - 58              |              |
|                                             |       |          |           | QC 8 - 8               |              |
|                                             |       |          |           | QC 8 - 9               |              |
|                                             |       |          |           | QC 8 - 68              |              |
|                                             |       |          |           | QC 8 - 67              |              |
|                                             |       |          |           | QC 8 - 1 (A)           |              |
|                                             |       |          |           | QC 8 - 47              |              |
|                                             |       |          |           | QC 8 - 40              |              |
|                                             |       |          |           | QC 8 - 52              |              |
|                                             |       |          |           | QC 8 - 23              |              |
|                                             |       |          |           | QC 8 - 57              | SBL 19/10/23 |
|                                             |       |          |           | QC 8 - 76              |              |
|                                             |       |          |           | QC 8 - 61              |              |
| 130 Packaging 3-1 - Stock - B4B 8 pcs       |       | 11/28/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  | SBL 19/10/23 |
|                                             |       |          |           | Packaging 3 - 2 - B4B  |              |
|                                             |       |          |           | Packaging 3 - 3 - B4B  |              |
|                                             |       |          |           | Packaging 3 - 4 - B4B  |              |
|                                             |       |          |           | Packaging 3 - 5 - B4B  |              |
|                                             |       |          |           | Packaging 3 - 6 - B4B  |              |
|                                             |       |          |           | Packaging 3 - 7 - B4B  |              |
|                                             |       |          |           | Packaging 3 - 8 - B4B  |              |
|                                             |       |          |           | Packaging 3 - 9 - B4B  |              |
|                                             |       |          |           | Packaging 3 - 10 - B4B |              |
|                                             |       |          |           | Packaging 3 - 11 - B4B |              |
|                                             |       |          |           | Packaging 3 - 12 - B4B |              |
|                                             |       |          |           | Packaging 3 - 13 - B4B |              |
|                                             |       |          |           | Packaging 3 - 14 - B4B |              |
|                                             |       |          |           | Packaging 3 - 15 - B4B |              |
|                                             |       |          |           | Packaging 3 - 16 - B4B |              |
|                                             |       |          |           | Packaging 3 - 17 - B4B |              |
|                                             |       |          |           | Packaging 3 - 18 - B4B |              |
|                                             |       |          |           | Packaging 3 - 19 - B4B |              |
|                                             |       |          |           | Packaging 3 - 20 - B4B |              |
|                                             |       |          |           | Packaging 3 - 21 - B4B |              |
|                                             |       |          |           | Packaging 3 - 22 - B4B |              |
|                                             |       |          |           | Packaging 3 - 23 - B4B |              |
|                                             |       |          |           | Packaging 3 - 24 - B4B |              |
|                                             |       |          |           | Packaging 3 - 25 - B4B |              |
|                                             |       |          |           | Packaging 3 - 26 - B4B |              |
|                                             |       |          |           | Packaging 3 - 27 - B4B |              |
|                                             |       |          |           | Packaging 3 - 28 - B4B |              |
| Plex 10/17/19 9:04 AM Dart.lajeunesse.marie |       |          |           |                        |              |

|                                                                               |                    |              |                |                        |     |
|-------------------------------------------------------------------------------|--------------------|--------------|----------------|------------------------|-----|
|                                                                               |                    |              |                | Packaging 3 - 29 - B4B |     |
|                                                                               |                    |              |                | Packaging 3 - 30 - B4B |     |
|                                                                               |                    |              |                | Packaging 3 - 31 - B4B |     |
|                                                                               |                    |              |                | Packaging 3 - 32 - B4B |     |
|                                                                               |                    |              |                | Packaging 3 - 33 - B4B |     |
|                                                                               |                    |              |                | Packaging 3 - 34 - B4B |     |
|                                                                               |                    |              |                | Packaging 3 - 35 - B4B |     |
|                                                                               |                    |              |                | Packaging 3 - 36 - B4B |     |
| 140 QC 21 - SA                                                                | 8 pcs              | 11/28/19     | 0.00 0.00      | QC 21 - SA - 21        |     |
|                                                                               |                    |              |                | QC 21 - SA - 70        | BAS |
|                                                                               |                    |              |                | QC 21 - SA - 53        | 21  |
| 9-23 OCT 24 2019                                                              |                    |              |                |                        |     |
| Part Op 100 - Turn blank for as per Folio FA046 DT8671                        |                    |              |                |                        |     |
| Descriptions: 110 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB) |                    |              |                |                        |     |
| 120 - QC8 Machining-4 (QC8- Inspect parts - second check)                     |                    |              |                |                        |     |
| 130 - Packaging3-2 (Identify as per dwg & Stock Location: LOCATION: MAT060    |                    |              |                |                        |     |
| 140 - QC21 (QC21- Final Inspection - Work Order Release)                      |                    |              |                |                        |     |
| Job BOM                                                                       |                    |              |                |                        |     |
| Part / Item                                                                   | Component Name     | Quantity     | Operation      | Container              |     |
| D6104-003                                                                     | Round Billet, 17-4 | 8 pcs (1 ea) | 100-Doosan - 1 | 57041931               |     |
| Job Allocations                                                               |                    |              |                |                        |     |
| Operation                                                                     | Component Part     | Required     | Inventory      | Allocated              |     |
| 100-Doosan - 1                                                                | D6104-003          | 8            | 17             | 0                      |     |
| Part Specifications                                                           |                    |              |                |                        |     |
| Specifications could not be found.                                            |                    |              |                |                        |     |

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| DART AEROSPACE LTD                      |  | Work Order:  | 201974 |
| Description: Turning Detail for D2891-1 |  | Part Number: | DSK076 |
| Inspection Dwg: DSK076 Rev: A           |  | Page 1 of 1  |        |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

|               |       |       |                | Record Actual Dimensions |   |   |   |   |
|---------------|-------|-------|----------------|--------------------------|---|---|---|---|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                        | 2 | 3 | 4 | 5 |
| Lathe Section |       |       |                |                          |   |   |   |   |
| A             | 2.274 | 2.279 | 2.275          |                          |   |   |   |   |
| B             | 3.702 | 3.722 | 3.712          |                          |   |   |   |   |
| C             | 2.564 | 2.584 | 2.577          |                          |   |   |   |   |
| D             | 0.718 | 0.738 | 0.728          |                          |   |   |   |   |
| E             | 0.090 | 0.110 | 0.105          |                          |   |   |   |   |
| F             | 2.464 | 2.484 | 2.474          |                          |   |   |   |   |
| G             | 2.029 | 2.049 | 2.038          |                          |   |   |   |   |
| H             | 2.964 | 2.984 | 2.979          |                          |   |   |   |   |
| I             | 0.913 | 0.933 | 0.924          |                          |   |   |   |   |
| J             | 0.022 | 0.042 | 0.032          |                          |   |   |   |   |
| K             | 0.090 | 0.110 | 0.0975         |                          |   |   |   |   |
| L             |       |       |                |                          |   |   |   |   |
| M             |       |       |                |                          |   |   |   |   |
| N             |       |       |                |                          |   |   |   |   |
| O             |       |       |                |                          |   |   |   |   |
| P             |       |       |                |                          |   |   |   |   |

|                     |             |       |          |
|---------------------|-------------|-------|----------|
| Measured by:        | DAS 55 9-89 | Date: | 14/10/21 |
| Audited by:         | 57 9-89     | Date: | 14/10/23 |
| Prototype Approval: |             | Date: |          |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 08.04.22 | New Issue | KJ/JLM     |          |

|                                         |  |              |        |
|-----------------------------------------|--|--------------|--------|
| DART AEROSPACE LTD                      |  | Work Order:  | 201974 |
| Description: Turning Detail for D2891-1 |  | Part Number: | DSK076 |
| Inspection Dwg: DSK076 Rev: A           |  | Page 1 of 1  |        |

FIRST ARTICLE INSPECTION DIMENSION SHEET

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|---------------|-------|-------|----------------|--------------------------|---|---|---|---|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                        | 2 | 3 | 4 | 5 |
| Lathe Section |       |       |                |                          |   |   |   |   |
| A             | 2.274 | 2.279 |                |                          |   |   |   |   |
| B             | 3.702 | 3.722 |                |                          |   |   |   |   |
| C             | 2.564 | 2.584 |                |                          |   |   |   |   |
| D             | 0.718 | 0.738 |                |                          |   |   |   |   |
| E             | 0.090 | 0.110 |                |                          |   |   |   |   |
| F             | 2.464 | 2.484 |                |                          |   |   |   |   |
| G             | 2.029 | 2.049 |                |                          |   |   |   |   |
| H             | 2.964 | 2.984 |                |                          |   |   |   |   |
| I             | 0.913 | 0.933 |                |                          |   |   |   |   |
| J             | 0.022 | 0.042 |                |                          |   |   |   |   |
| K             | 0.090 | 0.110 |                |                          |   |   |   |   |
| L             |       |       |                |                          |   |   |   |   |
| M             |       |       |                |                          |   |   |   |   |
| N             |       |       |                |                          |   |   |   |   |
| O             |       |       |                |                          |   |   |   |   |
| P             |       |       |                |                          |   |   |   |   |

|              |  |       |  |
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| Measured by: |  | Date: |  |
|--------------|--|-------|--|

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|-------------|--|-------|--|
| Audited by: |  | Date: |  |
|-------------|--|-------|--|

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| Prototype Approval: |  | Date: |  |
|---------------------|--|-------|--|

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 08.04.22 | New Issue | KJ/JLM     |          |

|                                                                                                                                                                                                                                                     |             |                              |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |  |  |  |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|------------------------------|--|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--|--|
| NCR No.                                                                                                                                                                                                                                             |             | Job: _____<br>Part No. _____ |  | DISPOSITION<br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  | DEPARTMENT/PROCESS<br>Skid-tube <input type="checkbox"/> Cross tube <input type="checkbox"/> Eng. (Non-AW) <input type="checkbox"/><br>Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/><br>Large Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/><br>Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/> |  |  |  |  |  |
| Date :                                                                                                                                                                                                                                              | Sequence #: | QTY Affected :               |  | MRB (QS1042)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |  |  |  |  |
| Description Work Order Deviation                                                                                                                                                                                                                    |             |                              |  | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |  |  |  |  |
| <div>Root Cause</div> <div><div>Operator</div><div>Manufacturing Process</div><div>Equip/Tooling</div><div>Handling/Preservation</div><div>Material</div><div>Product Improvement</div><div>Process Improvement</div><div>Human Factors</div></div> |             |                              |  | <div>FAULT CATEGORY</div> <div><div>Pressure/Forced</div><div>Bending</div><div>Crushing</div><div>Cracks</div><div>Crimp/Kink/Ripple/Wave/Twist</div><div>Marks/Chatter</div><div>Mislabeled</div><div>Other/Details:</div></div> <div><div>Contamination</div><div>Misaligned/off center</div><div>BOM/Route</div><div>Broken/Damage/Defect</div><div>Incomplete/Unclear Instructions</div><div>Drill Holes</div><div>Fit/Function</div></div> <div><div>Power Loss/Surge</div><div>Folio/Program</div><div>Grain Direction</div><div>Weld</div><div>Wrong Stock Pulled</div><div>Out of Sequence</div><div>Off-set/Set-up</div></div> <div><div>Positioned Wrong</div><div>Outside Tolerance</div><div>Drawing</div><div>Finish</div><div>Part Lost/Missing</div><div>Misread</div></div> |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |  |  |  |  |